	dey, 11/22/2005 4:58:32 PM a Lacelle	ss Sheet		
Customer Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Approx	: CU-DAR001 Dart Helicopters Services : 24943 : 10453 : N IP : 11/22/2005 S.O. No. : NIT : NC : 11/22/2005 Type : MACHINED PARTS : 24748 : See comment below : See comment below : Est Rev: C 00.06.22 Removed P/O for powder	Part Number Drawing Number Project Number Drawing Revision Material Due Date	: FWD MOUNTING LUG : D26162 : D2616 REV D3 : N/A : D3 : N/A : D3 : N/A : 12/2/2005 Qty:	30 Um : Each
Additional Produc		<		
Job Number:				
Seq.#:	Machine Or Operation:	Description :		(1)
1.0	M6061T6B1000X02000 6061-T6 B	3er 1.0" x 2.0"		
Comm	ent: Qty.: 0.1749 f(s)/Unit Total : 5.2479 f(s) Material: 6061-T6 QQ-A-200/8 2" X 1" Bar Batch /1 /90 59		ANT 08/1/26	36
2.0	BAND SAW BAND SA	W		
Comm	ent: BAND SAW		_ / / /	
	Cut blanks: 2.000" long +0.030" -0.000"		me odula4	3 <i>o</i>
3.0	HAAS CN	IC VERTICAL MACHINING		•
Comm	ent: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2616-2 & DWG D2616			
	2-Tumble & Deburr	N	B 05/11/27	30
4.0	QC2 INSPECT	PARTS AS THEY COME O	FF MACHINE	-
Comm	ent: INSPECT PARTS AS THEY COME OFF MACHINE	~	& oslular	30
5.0	QC8 SECOND	CHECK		
Comm	ent: SECOND CHECK	<u> </u>	0 05/11/28	30
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Part No:

W/O: ~	** 1. /	WORK ORDER CHANGES								
DATE	STEP	·	PROCEDURE CHANGE	: :	Paragraphical State of State o	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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PAR #: _____ Fault Category: __

NCR: Yes NO DQA: Date: 05/12/03

		ì	1	QA: N	/C Closed:	Date: _				
	WORK ORDER NON-CONFORMANCE (NCR)									
STEP	Description of NC Section A	Initial Chief-⊊ng	Corrective Action Action Descrip		Verification Section C	Approval Chief Eng	Approval QC Inspecto			
3	I piece too small the siece more in the vise			and and	1 D	W OFF	B			
:	vas wrong	Q-11-10			00 11 00					
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		STEP Description of NC Section A	STEP Description of NC Section A Initial Chieffing I piece too small the piece more in the vise I piece scrap, program was wrong The program was wrong	STEP Description of NC Section A Initial Chieffing Chieffing The piece too small the piece move in the vise paragraphy program was wrong Corrective Action Action Description Chief Eng Chief Eng Alestroy and recording the piece was wrong Alestroy and recording the piece was wrong Alestroy and recording the piece was wrong Alestroy and recording the piece was wrong and recording the piece was wrong and recording the piece was a program was a program which was a program was a program which was a program when the piece was a program was a program which was a program w	WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Initial Chief Eng Action Description Chief Eng Chief Eng Action Description Chief Eng Action Description Chief Eng Action Description Chief Eng Action Description Chief Eng Oshib Action Description Chief Eng Oshib Action Description Chief Eng Oshib Oshib Action Description Chief Eng Oshib Oshib	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Chieffing	WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Initial Chief Eng Action Description Chief Eng Action Description Chief Eng Approval Chief Eng			

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

,	sday, 11/22/2005 4:58:32 PM la Lacelle	Process Sheet	
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: FWD MOUNTIN	GLUG
•			
Job Number:	24943	Part Number: D26162	
Job Number:			
Seq.#:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comme	ent: HAND FINISHING RESOURCE #1	100544	1.112 20
7.0	Chemical Conversion Coat as per QS POWDER COATING	POWDER COATING	05/11/23 30
7.0	TA III III III III	FOWDER GOATING	
Comme	Powder Coat Grey Sandtex (Ref. 4.3.)	5.6) as per OSI 005.4.3	
	Note:Mask large hole	0.0) as per doi 000 4.0	/11/29 36
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVER	SION/
			J 05:11:30 30
Comme	ent: INSPECT POWDER COAT/CHEMICA	AL CONVERSION	
9.0	D2611	Bearing	i (AE) (4 ESL) 108)
Comme	ent: Qty.: 1.0000 Each(s)/Unit Total:	30.0000 Each(s)	
	Pick:	P. 4 4	
	Qty Part Number Description 1 D2611 Bearing	Batch B24411	
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		SB ostulza	
Comme	ent: SMALL & MEDIUM FAB RESOURCE		
	1-Coat bearing in light oil	\$:
	2-Press Bearing in D2616-2		
	-		
	3-Stack as per Dwg D2616 using DT8		1 1.
	4- Touch up paint if required	MADE OF MADRIC TO CURDENT OFFI	02 11/30
11.0	QC5	INSPECT WORK TO CURRENT STEP	
			Lw.11.30 30
Comme	ent: INSPECT WORK TO CURRENT STE	<u> </u>	ν
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Part No:	PAR #:	Fault Category:	 NCR: Yes/No) DQA:	: Date: ⊘5//∂./0℃
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NCR:	,	WORK ORDER NON-CONFORMANCE (NCR)									
DATE	0.750	Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE STEP		Section A	Initial: Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
Ø5·11·30	9	Parts were noticed to be 0.8150.0.003 over MAX dimension of 0.8120. bearing can be installed they by hand, barely any press fit required.	Money	Plants Are acceptable State booming in Splaces each side	SB 55/11/30	05-18-30	18 OFFID	W-11-30			
· ·		hand, bowely any press fit required.	i		5	i.,		1			
			1000 1000 1000 1000 1000 1000 1000 100								

NOTE: Date & initial all entries

Tuesday, 11/22/2005 4:58:32 PM Date: 🧇 User: Linda Lacelle **Process Sheet Drawing Name: FWD MOUNTING LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 24943 Part Number: D26162 Job Number: Seq. #: Description: **Machine Or Operation:** 12.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 05/12/01 30 Location: 140 DOCUMENT CONTROL 13.0 Comment: DOCUMENT CONTROL

Inspection Level 21

Jul 05/12/05

Job Completion

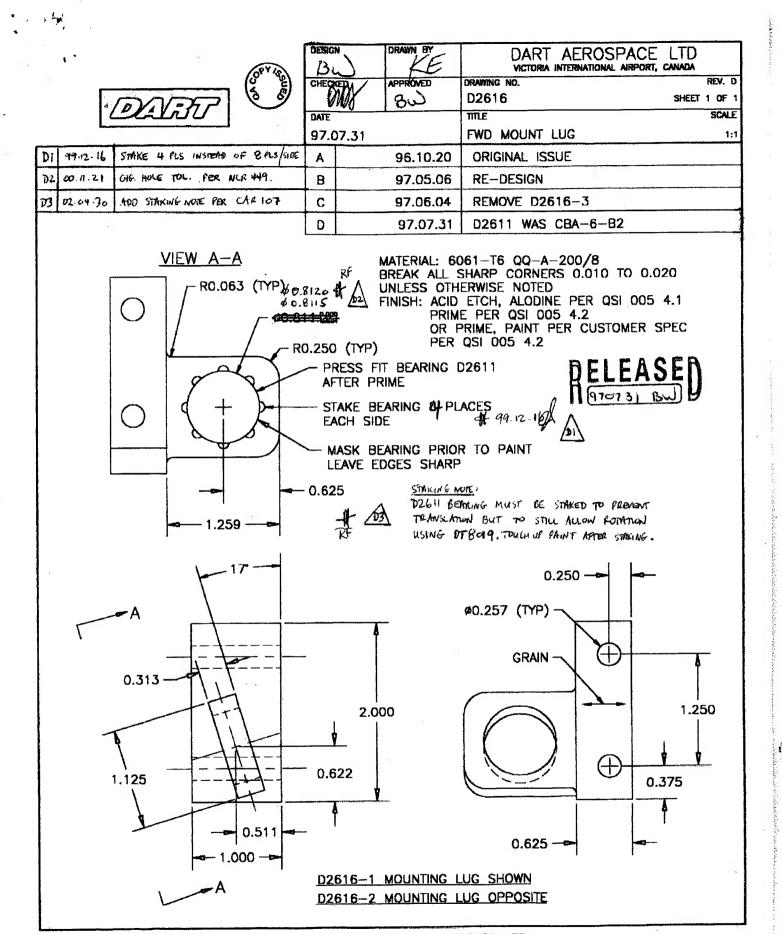


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Part No	:	PAR #: Fault Category:	NC	R: Yes	No DQ	A :	i Date:	·
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NCR:		WORK ORDER NON-CONFORMANCE (NC					1	3 *	
		Description of NC	1166	Corrective Action Secti	on B	Verification	Approval	Approva	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto	
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NOTE: Date & initial all entries



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Description: F	WO MOU	NTING LU	6		Part Number:	02616-2
Inspection Dwg:	D2616 Rev	: D3				Page 1 of 1
	FIRS.	T ARTICLE IN	SPECTION	ON CHE	CKLIST	
	[First Artic	:le	Proto	otype	
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